

orelen 11153

Phu

28 Dec



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.7308

Job Sheet 186266



7139

Part No: 647.7308

Job Qty: 1 ea

Part Name: EC135 T3/P3 Cable Cutters (Removable Provisions Only)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/13/18

Job Tracking No:

Due Date: 12/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV N/C SHEETS 38-40

Ship Via:

7139

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/28/18	0.00	0.00	Start Up Stores/Pkg-1		DEC 20 2018
110	Packaging	1 pcs		12/28/18	0.00	0.00	Packaging1-1		DAS 24 2018
120	QC	1 pcs		12/28/18	0.00	0.00	QC4		46 DEC 27 2018
130	Packaging	1 pcs		12/28/18	0.00	0.00	Packaging3-1		948 DEC 27 2018
135	DC	1 pcs		12/28/18	0.00	0.00	DC		288 18.12.27 DAS
140	QC21-FG	1 Ea		12/28/18	0.00	0.00	QC21		ms 18.12.27 70 9-89

Part Op 130 - Identify and pack for shipping as per PPP MPP-195 (647.7308)
Descriptions: 135 - Photocopy bluefile & type labels per PPP MPP-195 (647.7308)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
601.3011	P-Seal	1.4000 ft (1.4 ea)	90-Start up Operation	5006166
647.7501	Lower Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	7139822
647.7702	Strut Assembly	2 Ea (2 ea)	90-Start up Operation	5118876
647.7701	Strut Assembly	2 Ea (2 ea)	90-Start up Operation	5132792
647.0112	Strut Bracket	4 Ea (4 ea)	90-Start up Operation	5097197X3 51332 11X1
MS21266-2N	Grommet	8 Ea (8 ea)	90-Start up Operation	5129988
AN44-12A	Eyebolt	2 Ea (2 ea)	90-Start up Operation	5131204
AN665-34R	Clevis	4 Ea (4 ea)	90-Start up Operation	5135097X1 5127344X3
AN3-11A	Bolt	4 Ea (4 ea)	90-Start up Operation	5098034X1 5130322X3
AN4C7A	Bolt	4 Ea (4 ea)	90-Start up Operation	5095478
NAS6603-12	Bolt	4 Ea (4 ea)	90-Start up Operation	5007044
NAS6603-16	Bolt	4 Ea (4 ea)	90-Start up Operation	5131203
MS21042-3	Nut	4 Ea (4 ea)	90-Start up Operation	5108577
MS21042L4	Nut	4 Ea (4 ea)	90-Start up Operation	512434
AN316C4R	Nut, Jam	4 Ea (4 ea)	90-Start up Operation	5130135
MS27039-08-13	Screw	4 Ea (4 ea)	90-Start up Operation	5096508X4 5123937X3
NAS1149FN832P	Washer	23 Ea (23 ea)	90-Start up Operation	5107701 51363 6 Fx 8
NAS1149F0332P	Washer	8 Ea (8 ea)	90-Start up Operation	5133206
NAS1149C0432R	Washer	12 Ea (12 ea)	90-Start up Operation	5103990
NAS1149F0532P	Washer	2 Ea (2 ea)	90-Start up Operation	5180574
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	90-Start up Operation	5132228
601.2045	RTV (LOCTITE 598)	1 Ea (1 ea)	90-Start up Operation	5087065

Exp 5/19
Exp 3/20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Re-tagging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																	
Date : _____	Step #: _____	MRB (QSI042) Approval																																																	
Description Work Order		Completed By																																																	
 DART AEROSPACE Container No: S140257 Part: 647.7308 Job No: 186266 Serial No/Batch: S140257 Revision: NC Inspector: _____ Exp Date: _____ Instructions: URF-17-611 Date: 12/24/18		Lead hand / Supervisor Approval Verification																																																	
		QC / QA Coordinator Approval																																																	
		<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 25%;">Environment</td> <td style="width: 25%;">No Re-verification</td> <td style="width: 25%;">Positioned Wrong</td> <td style="width: 25%;"></td> </tr> <tr> <td>Design</td> <td>Operator</td> <td>Outside Dimensions</td> <td></td> </tr> <tr> <td>Doc/Data</td> <td>Offset/Setup</td> <td>Over/Under tolerance</td> <td></td> </tr> <tr> <td>Equip/Tooling</td> <td>Supplier</td> <td>Part Incorrect</td> <td></td> </tr> <tr> <td>Handling/Pre</td> <td>Training</td> <td>Part Lost/Missing</td> <td></td> </tr> <tr> <td>Material</td> <td>Use for Testing</td> <td>Part Moved</td> <td></td> </tr> <tr> <td>Internal Transport</td> <td>Poor Information</td> <td>Drawing</td> <td></td> </tr> <tr> <td>Tribal Knowledge</td> <td>Rushing</td> <td>Finish</td> <td></td> </tr> <tr> <td>LOA</td> <td>Product Improvement</td> <td>Misread</td> <td></td> </tr> <tr> <td>Substation</td> <td>Process Improvement</td> <td>Turning Sequence</td> <td></td> </tr> <tr> <td>Past Expiry Date</td> <td>Manufacturing Process</td> <td></td> <td></td> </tr> <tr> <td>Misidentified</td> <td>Past Due</td> <td></td> <td></td> </tr> </table>				Environment	No Re-verification	Positioned Wrong		Design	Operator	Outside Dimensions		Doc/Data	Offset/Setup	Over/Under tolerance		Equip/Tooling	Supplier	Part Incorrect		Handling/Pre	Training	Part Lost/Missing		Material	Use for Testing	Part Moved		Internal Transport	Poor Information	Drawing		Tribal Knowledge	Rushing	Finish		LOA	Product Improvement	Misread		Substation	Process Improvement	Turning Sequence		Past Expiry Date	Manufacturing Process			Misidentified	Past Due
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OTHER : _____																																																			

MS27039-08-19	Screw	5 Ea (5 ea)
MS21042L08	Nut	9 Ea (9 ea)
647.1702	Skid Deflector Assembly	2 Ea (2 ea)
LN9025-0820K	Lock Tab Washer	8 Ea (8 ea)
LN9037-08018	Screw	8 pcs (8 ea)
93635A212	Bolt	4 Ea (4 ea)
601.3902	Eye Bolt	2 Ea (2 ea)
647.1405	EC135 Upper Cutter Assembly	1 Ea (1 ea)

90-Start up Operation
 90-Start up Operation
 90-Start up Operation
 90-Start up Operation
 90-Start up Operation
 90-Start up Operation
 90-Start up Operation
 90-Start up Operation

504359
 5100409
 5736992
 5094434
 5042638x5 5099338x3
 5021320
 5026005
 5136940

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	600.1012	1	22	0
	601.2045	1	19	0
	601.3011	1	135	0
	601.3902	2	43	0
	647.0112	4	76	0
	647.1405	1	0	0
	647.1702	2	6	0
	647.7501	1	1	0
	647.7701	2	0	0
	647.7702	2	13	0
	93635A212	4	28	0
	AN3-11A	4	131	0
	AN316C4R	4	27	0
	AN44-12A	2	0	0
	AN4C7A	4	133	0
	AN665-34R	4	39	0
	LN9025-0820K	8	45	0
	LN9037-08018	8	137	0
	MS21042-3	4	180	0
	MS21042L08	9	1,539	0
	MS21042L4	4	2,014	0
	MS21266-2N	8	6	0
	MS27039-08-13	4	572	0
	MS27039-08-19	5	1,537	0
	NAS1149C0432R	12	1,850	0
	NAS1149F0332P	8	1,565	0
	NAS1149F0532P	2	1,127	0
	NAS1149FN832P	23	2,375	0
	NAS6603-12	4	59	0
	NAS6603-16	4	4	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					